



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10334-042-PO

Job Sheet 185663



Part No: RB 92700-10334-042-PO

Job Qty: 3 ea

Part Name: Sling Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/14/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB 92700-10334-042 Rev.A IPP Rev. A 18.10.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs	12/14/18	12/14/18	0.00	0.00	Purchasing		JAN 22 2019
110	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		JAN 22 2019
120	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC6		38
130	Small Fab	3 pcs	12/14/18	12/14/18	0.00	0.30	Small Fab-2		9-88
140	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC5		
150	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3		MLL
160	QC21-FG	3 Ea	12/14/18	12/14/18	0.00	0.00	QC21		JAN 22 2019

Part Op 100 - Issue P/O: 041341 MANUFACTURE RB 92700-10334-042 AS PER DWG Supplier: ARROW TECH MACHINE
Descriptions: WORKS - Certificate of conformity is required
130 - Re-identify as required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB 92700-10334-042P	Sling Assembly	3 Ea (1 ea)	100-Purchasing	S146642

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB 92700-10334-042P	3	0	0

Part Specifications

Specifications could not be found.



Container No: S146651



Part: RB 92700-10334-042

Job No: 185663

Serial No/Batch: S146651

Revision: A

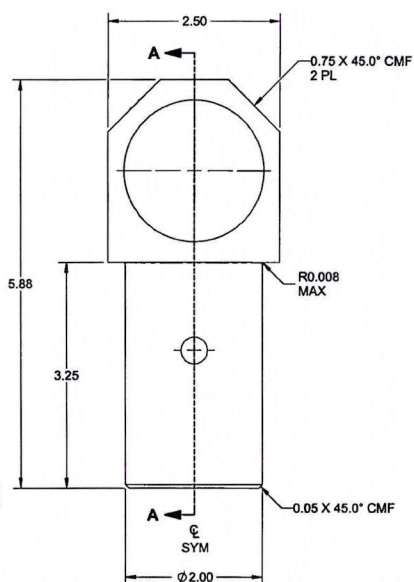
Inspector:

Exp Date:

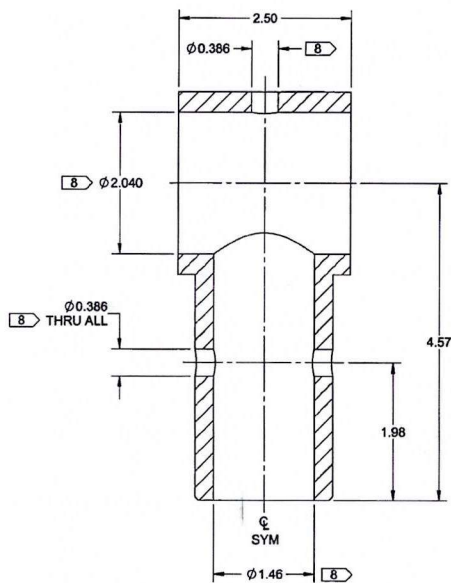
Instructions:

Date: 01/22/19

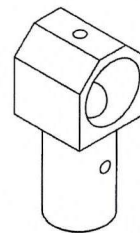
Plex 10/31/18 9:45 AM dart.Lussier.Patrick



RB 92700-10334-042-2 LIFTING TUBE



SECTION A-A

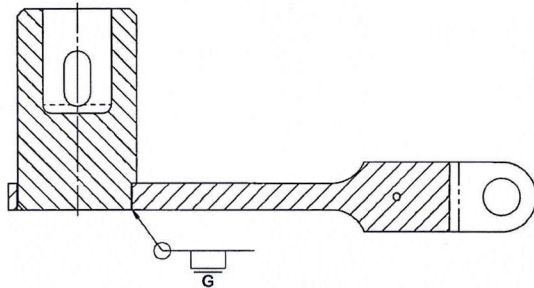


- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS THEN POWDERCOAT RED QSI 005 OR MIL-PRF-24712
 - 4) TOLERANCES: XX = ± 0.1 " / ± 1 "
 XXX = ± 0.01 " / ± 0.5 "
 XXXX = ± 0.005 " / ± 0.1 "
 XXXXX = ± 0.0005 " / ± 0.05 "
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) MASK HOLES AS SHOWN PRIOR TO POWDERCOAT

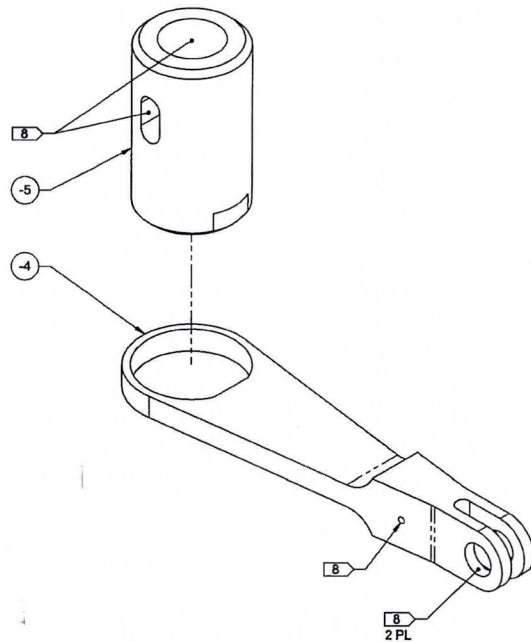
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 3 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/23/2018	SLING ASSEMBLY	NTS

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ITEM #	QTY	PART #	PART TITLE
-4	1	RB 92700-10334-042-4	LEFT HAND CLEVIS
-5	1	RB 92700-10334-042-5	LEFT HAND TUBE CONNECTOR

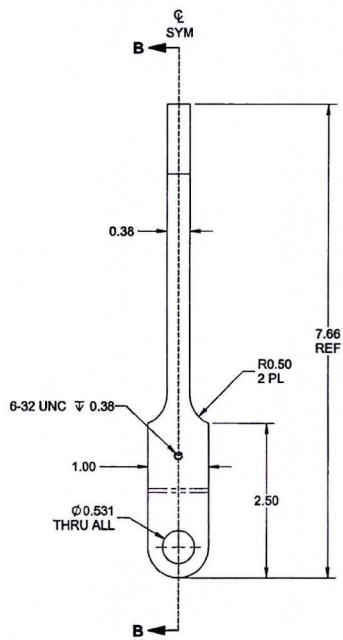


RB 92700-10334-042-3 LEFT HAND CLEVIS WELDMENT

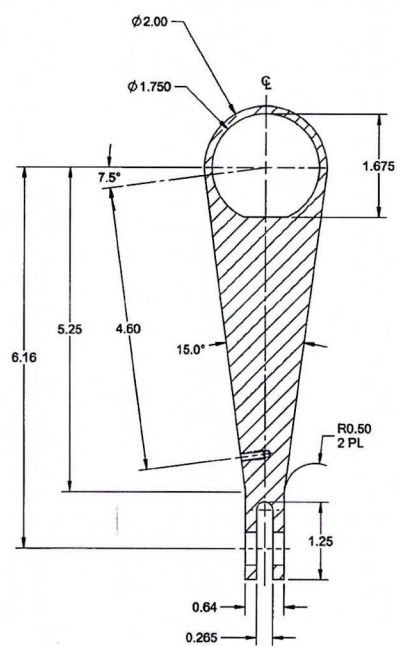


- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13824 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS THEN POWDERCOAT RED OSI 005 OR MIL-PRF-24712
 - 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) MASK HOLES AND SLOT AS SHOWN PRIOR TO POWDERCOAT

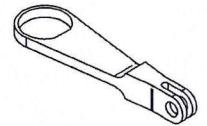
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 4 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/23/2018		SLING ASSEMBLY	NTS
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RB 92700-10334-042-4 LEFT HAND CLEVIS



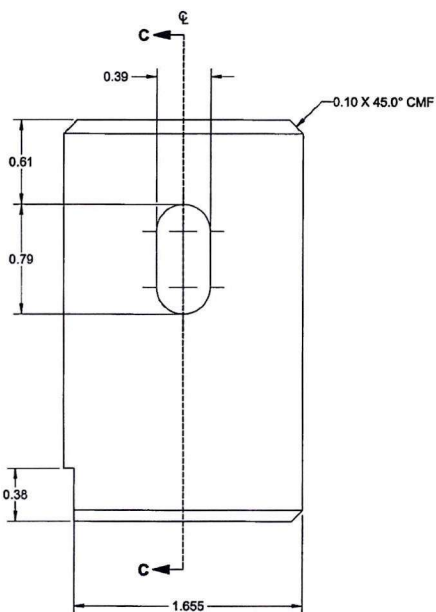
SECTION B-B



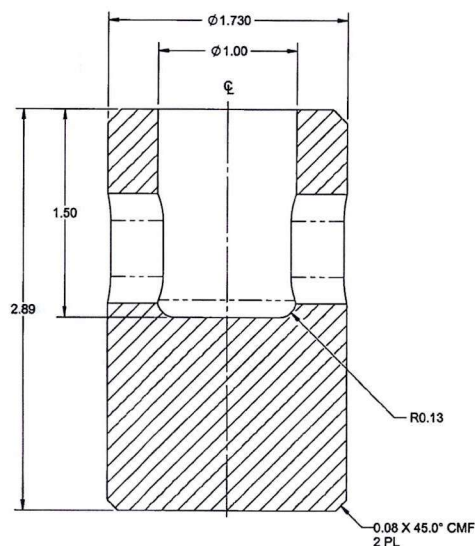
- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = ± 0.1 " / ± 1 "
X.XX = ± 0.01 " / ± 0.5 "
X.XXX = ± 0.005 " / ± 0.1 "
X.XXXX = ± 0.0005 " / ± 0.05 "
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 5 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/23/2018	SLING ASSEMBLY	NTS

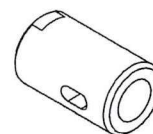
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RB 92700-10334-042-5 LEFT HAND TUBE CONNECTOR



SECTION C-C

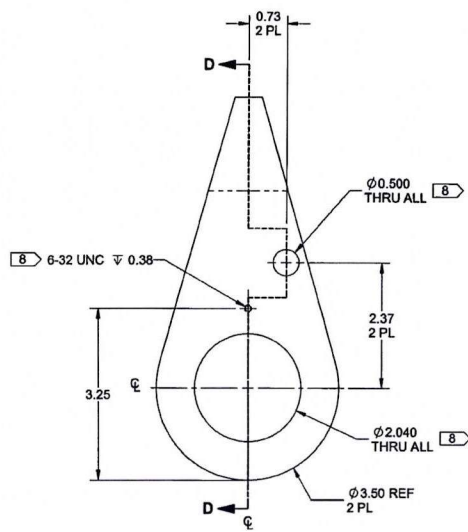


- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = ± 0.1 " / ± 1 "
X.XX = ± 0.01 " / ± 0.5 "
X.XXX = ± 0.005 " / ± 0.1 "
X.XXXX = ± 0.0005 " / ± 0.05 "
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

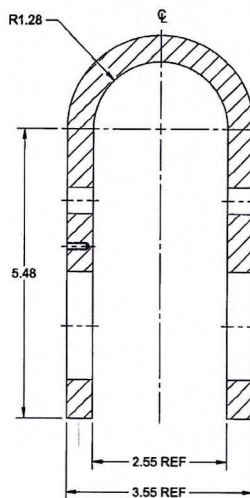
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 6 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/23/2018	SLING ASSEMBLY	NTS

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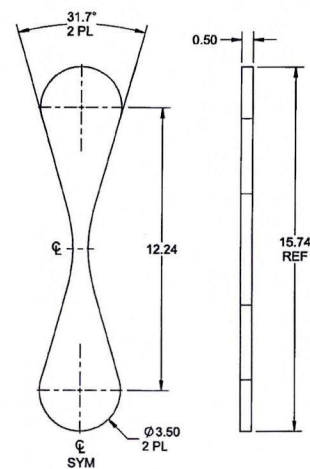
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RB 92700-10334-042-6 LIFTING LUG



SECTION D-D



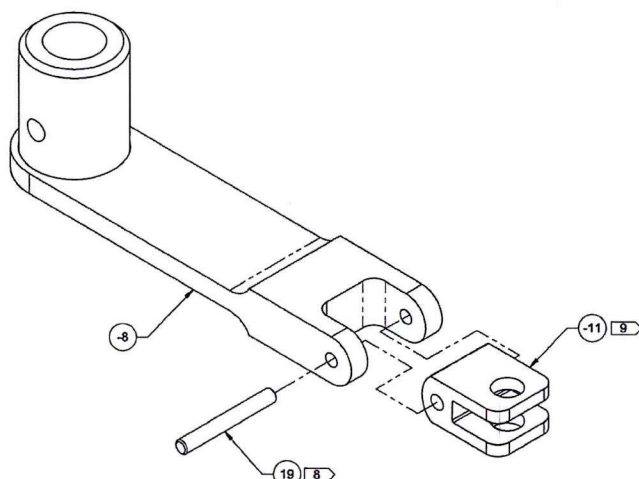
**RB 92700-10334-042-6F
(FLAT PATTERN)**

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS THEN POWDERCOAT RED QSI 005 OR MIL-PRF-24712
 - 4) TOLERANCES: X.X = ± 0.1 / ± 1
X.XX = ± 0.01 / ± 0.5
X.XXX = ± 0.005 / ± 0.1
X.XXXX = ± 0.0005 / ± 0.05
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) MASK HOLES AS SHOWN PRIOR TO POWDERCOAT
 - 9) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF ± 0.005 " PER CAD FILE RB 92700-10334-042-6 STEP

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 7 OF 12
APPROVED	<i>M. De</i>	TITLE	SCALE
DATE	10/23/2018	SLING ASSEMBLY	NTS

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ITEM #	QTY	PART #	PART TITLE
-8	1	RB 92700-10334-042-8	RIGHT HAND CLEVIS WELDMENT
-11	1	RB 92700-10334-042-11	RIGHT HAND CLEVIS END
19	1	McMaster#98381A336 OR EQUIV.	STEEL DOWEL PIN 1/4" DIA. X 2" LG.



RB 92700-10334-042-7 RIGHT HAND CLEVIS ASSEMBLY

NOTES:

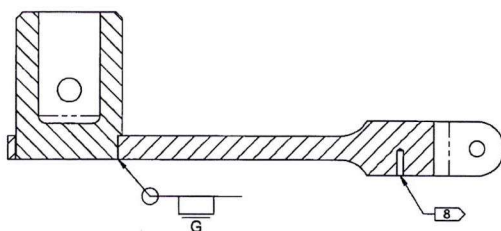
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 19 WITH ITEM -8 AND REMOVE EXCESS
- 9) ITEM -11 MUST ROTATE FREELY AROUND ITEM 19

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 8 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/23/2018	SLING ASSEMBLY	NTS

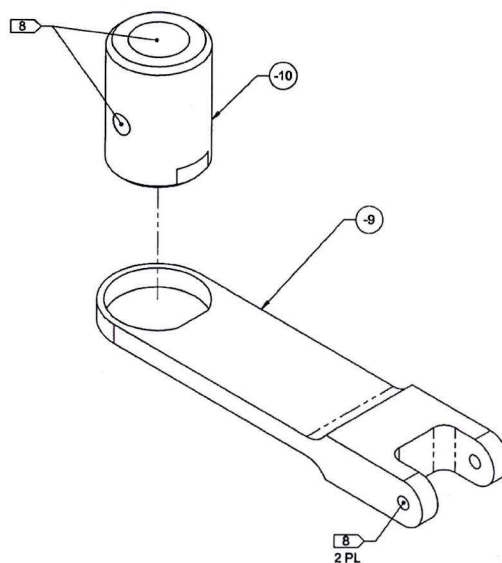
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ITEM #	QTY	PART #	PART TITLE
-9	1	RB 92700-10334-042-9	RIGHT HAND CLEVIS
-10	1	RB 92700-10334-042-10	RIGHT HAND TUBE CONNECTOR



RB 92700-10334-042-8 RIGHT HAND CLEVIS WELDMENT

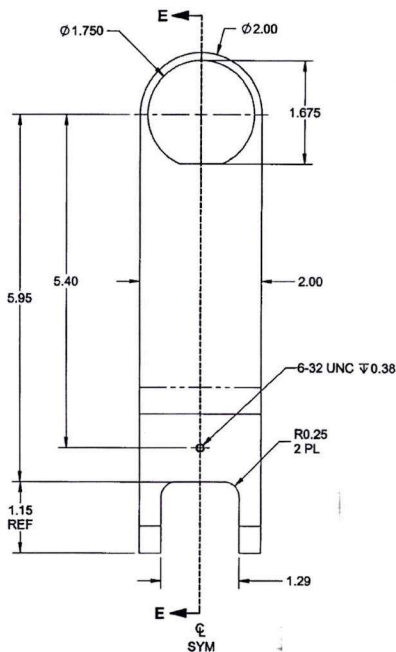


NOTES:

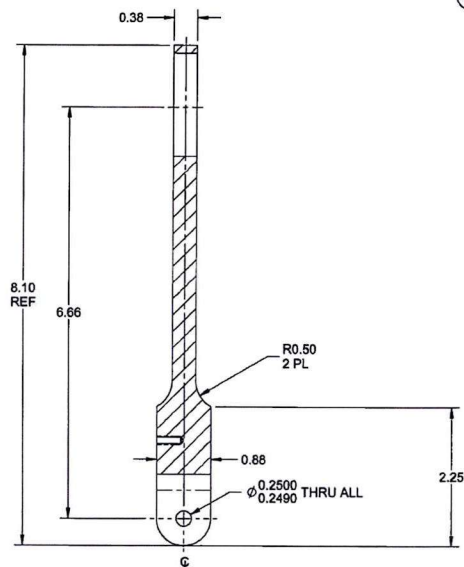
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS THEN POWDERCOAT RED OSI 005 OR MIL-PRF-24712
- 4) TOLERANCES: XX = ± 0.1 " / ± 1 "
 X.XX = ± 0.01 " / ± 0.5 "
 X.XXX = ± 0.005 " / ± 0.1 "
 X.XXXX = ± 0.0005 " / ± 0.05 "
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) MASK HOLES AS SHOWN PRIOR TO POWDERCOAT

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 9 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE	10/23/2018	SLING ASSEMBLY	NTS

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RB 92700-10334-042-9 RIGHT HAND CLEVIS



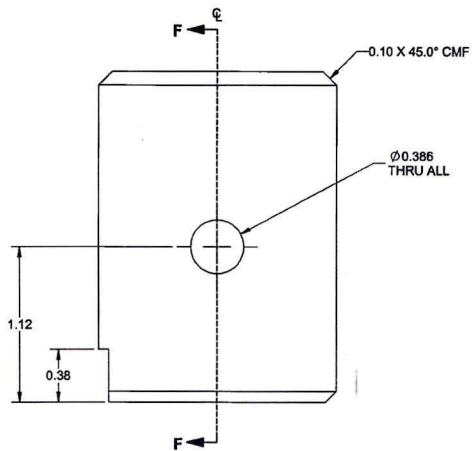
SECTION E-E

NOTES:

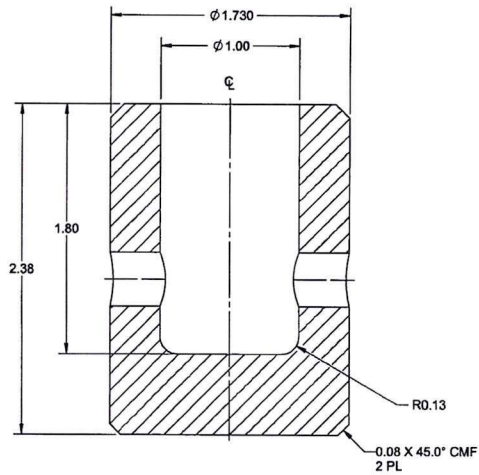
- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 10 OF 12
APPROVED	<i>ML</i>	TITLE	SCALE
DATE	10/23/2018	SLING ASSEMBLY	NTS

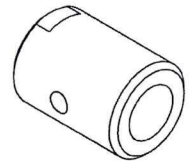
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RB 92700-10334-042-10 RIGHT HAND TUBE CONNECTOR



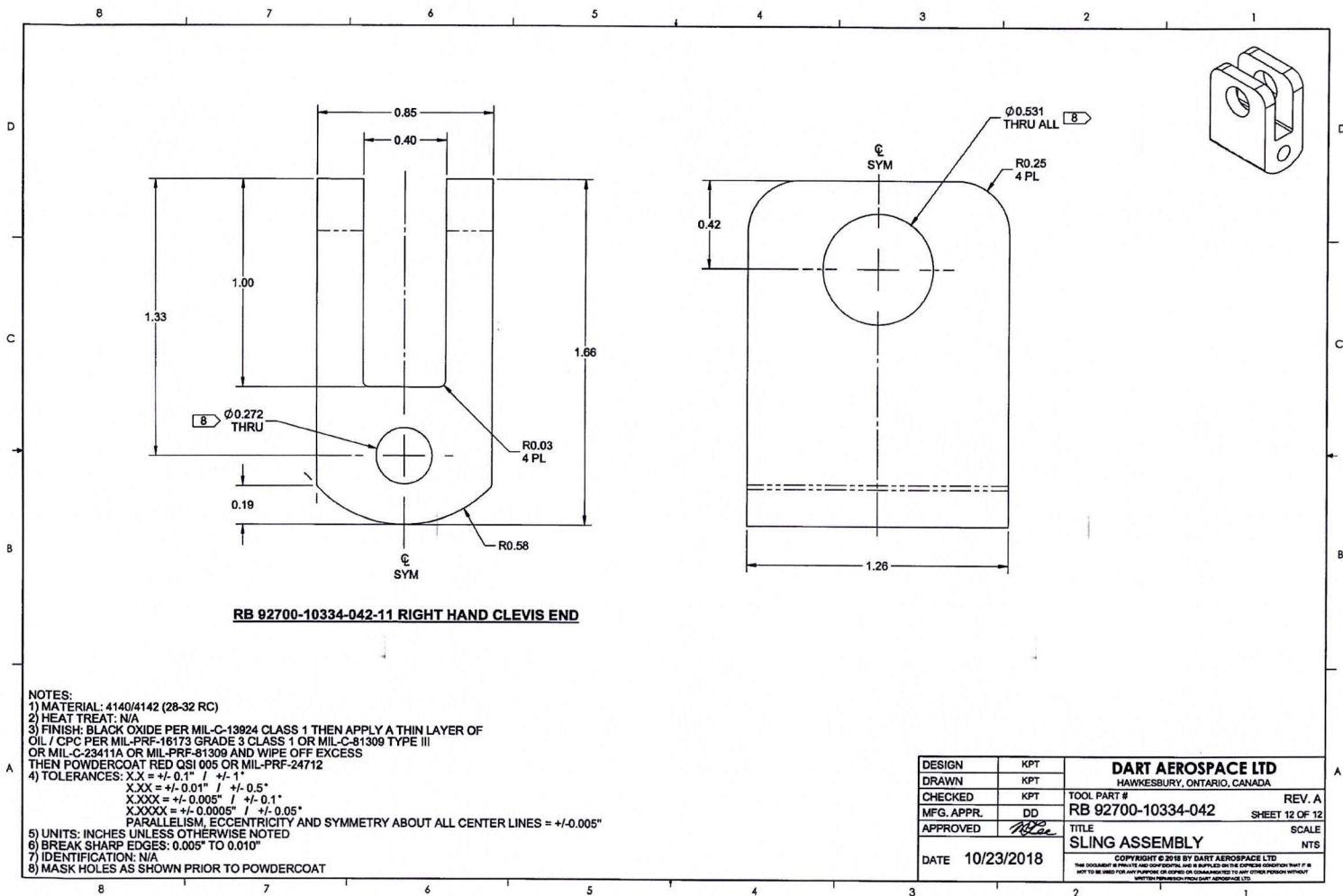
SECTION F-F



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10334-042	SHEET 11 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/23/2018	SLING ASSEMBLY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041341**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041341
PO Date: 10/12/18
Due Date: 12/21/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Belanger, NatashaPhone:

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
11	185622	RB 92700- 10301- 041P			Pitch Beam Puller REV A	Firmed	-	12/21/18	1 Ea	0 Ea	1 Ea	\$1,500.00/Ea	\$1,500.00
Line Item Note SIOP													
16	185663	RB 92700- 10334- 042P			Engine Lifting Sling REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$0.01/Ea	\$0.03
Line Item Note SIOP													
49	187974	RB 92700- 10301- 041P			Pitch Beam Puller	Firmed	-	12/21/18	2 Ea	0 Ea	2 Ea	\$0.01/Ea	\$0.02
Grand Total:												\$1,500.05	

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/28/18 2:04 PM dart.tsimiklis.chrisoula



**PHGE Machineworks dba
Arrowtech Machineworks**

29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 400

Date: 1/18/2019 ✓
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty
3 ✓

Item
ENGINE LIFTING SLING

Part No.
RB 92700-10334-042 ✓

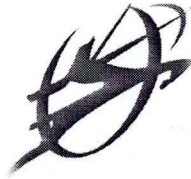
DAS
38
9-88

Received by:

Packaged by:

Checked by:

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041341 ✓

Dated: 1/18/2019

Our Order / Job No: 041341-16AWT

Order Qty: 3 ✓

Part Name: ENGINE LIFTING SLING

Part Number: RB 92700-10334-042 ✓

Lot Size: N/A

Ship Date: 1/18/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB 92700-10334-042

Rev: A

Material Size and Type: -1/A519; -2, -5, -10/4140Q&T; -4, -6, -9, -11/ 4140 STEEL

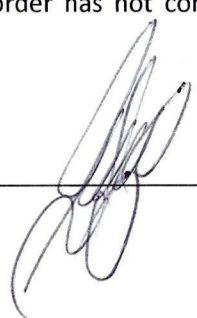
Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: -4 -6, -9, -11/ 30.0 HRC; (Q&T 28-32 RC)

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D; POWDER COAT RED QS 1005

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 01/19/19

Signed: 

DAS
38
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
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